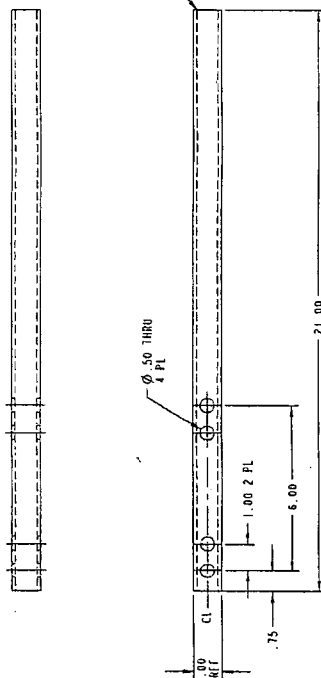
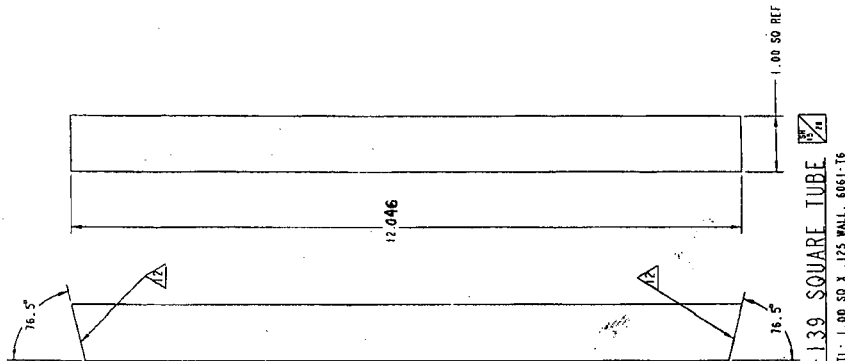


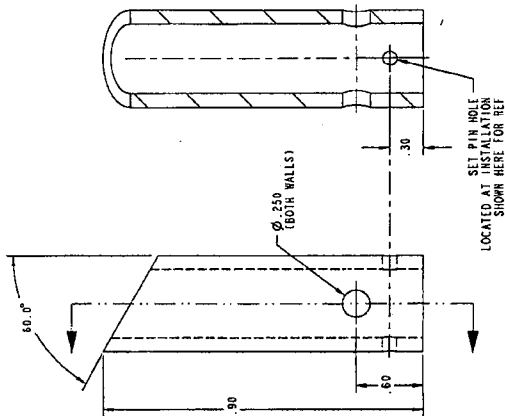
RELEASED
NOV 4 2000



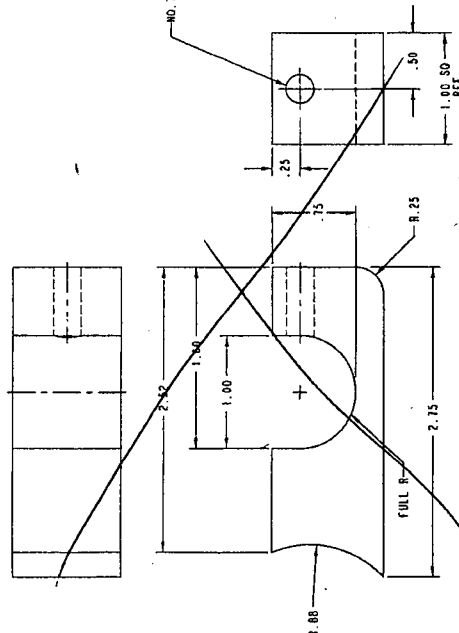
① -239 SQUARE TUBE
MATERIAL: 1.00 SQ. X .125 WALL, 6061-T6
SCALE: 0.500



① -139 SQUARE TUBE
MATERIAL: 1.00 SQ. X .125 WALL, 6061-T6
SCALE: 1.000



① -243 TUBE HANDLE EXTENSION
MATERIAL: .812 SQ. X .125 WALL, 6061-T6
SCALE: 2.000



① -241 TUBE DETENT CLIP
MATERIAL: 1.00 SQ. 6061-T6
SCALE: 2.000

SUPERCEDED BY
① D3440-9

PREMIER AVIATION, INC.
1000 West Aviation Parkway, Grand Prairie, Texas 75048
D105UV8 B67-43001 1st
DATE: 2/1/83

ORIGINAL

STOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1191

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 09/09/2008 1:06:16 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 41917

Part Number: PB6743001239

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	PB6743001225	Bushing
-----	--------------	---------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

batch: B40272

08.09.25 4

7.0	PB6743001223	Square Cap
-----	--------------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Square Cap

batch: B40042

08.09.25 4

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

08.09.25 4

9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr

08.09.25 4

10.0	QC10	VISUAL INSPECTION OF GROUND WELDS
------	------	-----------------------------------



Comment: VISUAL INSPECTION OF GROUND WELDS

08.09.26

08.09.26

11.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

08/09/26 (x4)

12.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SID

8/9/26

(1)

50

13.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

MF 08-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 09/09/2008 1:06:16 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SQUARE TUBE
 Job Number : 41917
 Estimate Number : 13421
 P.O. Number :
 This Issue : 09/09/2008 S.O. No. :
 Prsht Rev. : NC Part Number : PB6743001239
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : B6743001 P.6/ P.21
 Previous Run : 41909 Drawing Revision : B1
 Material :
 Due Date : 15/09/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : Jul 08.9.09
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6TS1000W120

6061T6 SQ TUBE 1.00 x 1.00 X .120w



Comment: Qty.: 1.8375 f(s)/Unit Total: 7.3500 f(s)

6061T6 SQ TUBE 1.00X.120

batch: m 109057

SAD

08/09/24

(4)

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut to length as per dwg

2- make a 0.090" chamfer on both ends of tube

3- deburr

SAD 08/09/24

(4)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/24 (4)

4.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- drill holes as per dwg

2- make a 0.090" chamfer (100 degree) on both side of the 4 holes

3- deburr

mmf 08/09/24

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/25 (4)